

Work Order ID 79092

79092

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Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, RH
 Start Date: 19/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	Rev E								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding								
110		0.00							
110	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

Ae 12/02/01

QC 12.02.01

Ae 12/02/09

(x4) \emptyset

4x \emptyset

(x4) \emptyset

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4	0		
140 *140* Small Fab Small Fab	Small Fab Memo 1- Drill Rivet holes as per dwg D3562. Touch up alodine 2- Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: <u>49785</u> <u>120666</u>	0.00 0.00				4	0		
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				12	02	23	(4)

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Large Fab	0.00							
	Memo	0.00							
	1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <u>119785</u> 2-Grind end cap welds flush as per Dwg D3562								
170 *170* QC	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
	Quality Control								
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	2	28/02/2012	
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8h45 OVEN TEMPERATURE: 320°F FINISH TIME: 9h15	0.00 0.00				4	2	28/02/28	
210 *210* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch _____ Memo M120125	0.00 0.00				4			

M120222

12-2-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00							
220									
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location: 6-A	0.00							
230									
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/29
 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D3562-042

D3562-042

Parent Item Name: Step Assembly, RH

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured No

100

Each

54.3700

1

4

D2622-120C

Step Extrusion

**

Ac 12/02/01

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA013

38

75781

38

D2734

Manufactured No

140

Each

118.0000

2

D2734

Step End Plate

**

12.02.23

Location

Loc Qty

Loc Code

WA

118

76985

118

D3560-042

Manufactured No

140

Each

0.0000

1

D3560-042

Arm Weldment

**

B 79084

12.02.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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79092

Parent Item: D3562-042

D3562-042

Parent Item Name: Step Assembly, RH

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3560-044

Manufactured No

140

Each

3.0000

1

4

D3560-044

Arm Weldment

B 79088

**

12.02.22

Location

Loc Qty

Loc Code

WA013

3

~~71950~~

3

4

MS20600-AD4W5

Purchased

No

160

Each

687.0000

32

128

MS20600-AD4W5

Blind Rivet

**

12.02.22

Location

Loc Qty

Loc Code

ST321

M/20570

681

114382

173

117505

82

118384

226

120142

200

WA018

6

111477

6

128

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3562-1,
MAKE FROM
EXTRUSION D2622

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

D3560-043 ARM WELDMENT

D3560-041 ARM WELDMENT

D3560-042 ARM WELDMENT

D3560-044 ARM WELDMENT

D3562-1,
MAKE FROM
EXTRUSION D2622

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

TRANSFER DRILL #30
DEBURR & TOUCH UP HOLES
WITH CHEMICAL CONVERSION
COAT BEFORE RIVETING
(32 PLACES PER STEP)

REFER TO STEP
END DETAIL

INSTALL MS20600AD4W5 RIVET
(32 PLACES PER STEP)

MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

UNCONTROLLED COPY

SUBJECT: D3562

WELDING: REF

NO. 39092 M.C.J.
12/01/19

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

D2734 END PLATE
(TYP 2 PLACES)

TYPICAL STEP END DETAIL
SCALE 1:2

D3562-041 LH STEP ASSEMBLY

D3562-042 RH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
GREY SANDTEX (4.3.5.6) OR
BLACK SANDTEX (4.3.5.7) OR
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3562-041	LH STEP ASSEMBLY
		D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN	84		
CHECKED	16		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3562

TITLE
STEP ASSEMBLY

REV. E

SHEET 1 OF 1

SCALE
1:5

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